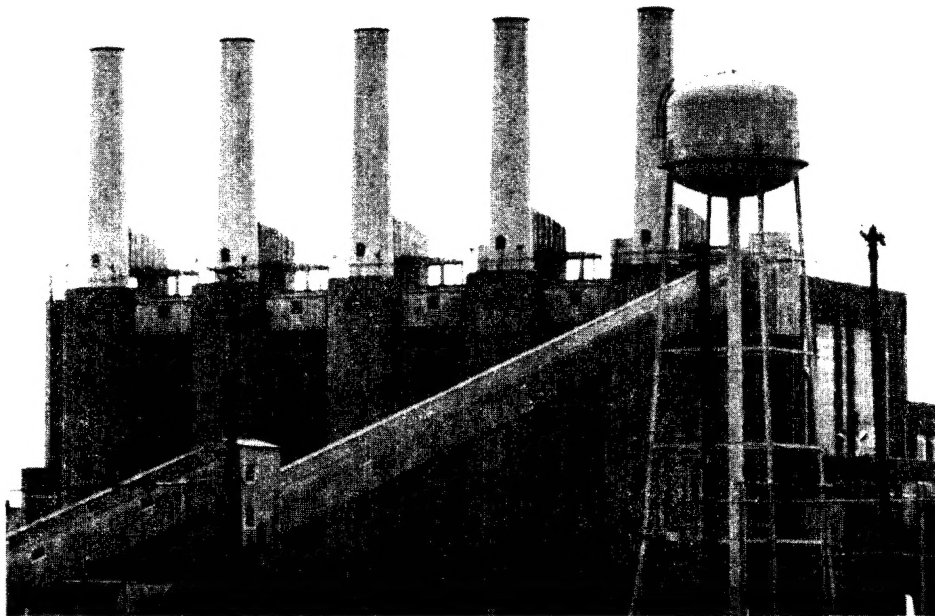


FINAL SUBMISSION

EXECUTIVE SUMMARY

**Steam/Power Plant Modernization Program
for
Indiana Army Ammunition Plant**



Prepared for



The Department of the Army

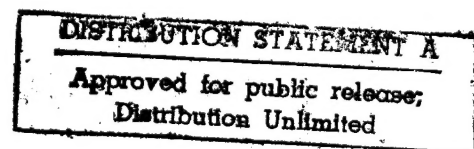
Omaha District
Corps of Engineers
Contract No. DACA45-80-C-0090

By



Sanders & Thomas, Inc.

An STV Engineers Professional Firm
Consulting Engineers
Pottstown, Pennsylvania 19464



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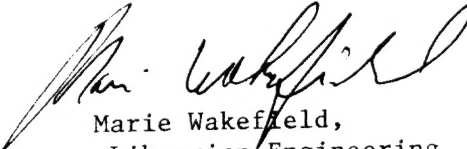


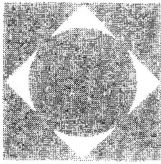
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June 17, 1983

U. S. Army Corps of Engineers
Omaha District
6014 U. S. Post Office and Court House
Omaha, NE 68102

Attention: MROED-MC
Reference: Steam/Power Plant Modernization Study
(Modified Increment E)
Indiana Army Ammunition Plant
Charlestown, Indiana
Subject: Final Submission
Contract No.: DACA45-80-C-0090
Our Project No: 05-4660

Gentlemen:

Enclosed is the Final Submission of the Executive Summary for the
Steam/Power Plant Modernization Study at the Indiana Army Ammunition Plant.

The Study consists of five volumes: (1) Executive Summary, (2) Report,
(3) Appendix I: Calculations, (4) Appendix II: Drawings, and (5) Appendix
III: Computer Output.

The Study presents alternative approaches to satisfying the plant's steam
demands during peacetime and mobilization periods including the applicability
of central boiler plants. A recommended plan is presented representing the
most cost-effective and technically practical plan for steam/power plant
modernization.

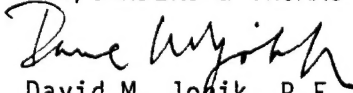
This submittal incorporates all applicable comments by plant personnel and
reviewing agencies.

This plan represents a combined effort of Sanders & Thomas and various Army
Departments. We wish to thank all who were involved in the preparation and
review of this report.

Thank you for this opportunity to be of continued service.

Very truly yours,

STV/SANDERS & THOMAS


David M. Jomik, P.E.
Project Manager

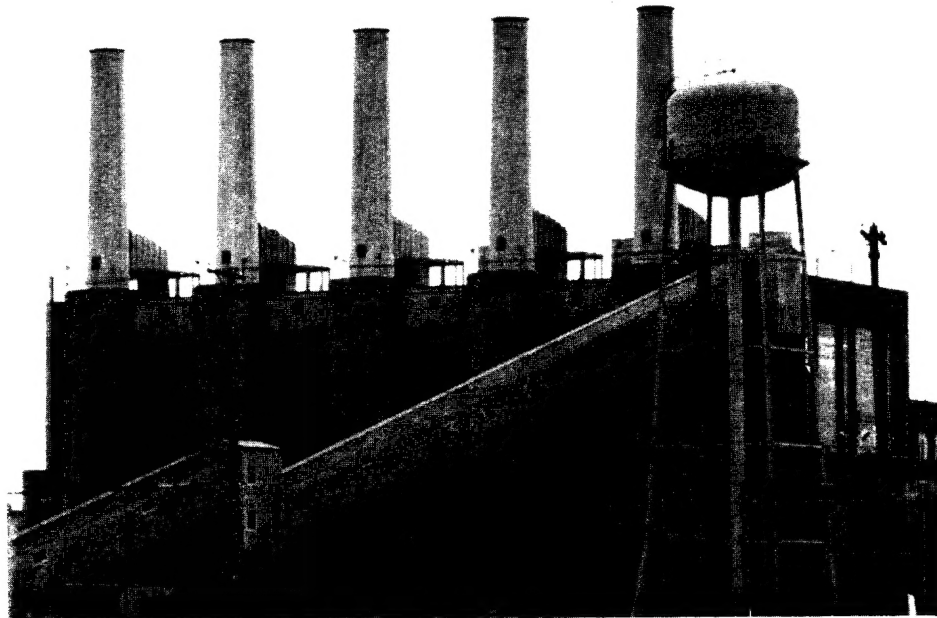
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Enclosure

FINAL SUBMISSION

EXECUTIVE SUMMARY

Steam/Power Plant Modernization Program for Indiana Army Ammunition Plant



Prepared for



The Department of the Army

Omaha District
Corps of Engineers
Contract No. DACA45-80-C-0090

By



Sanders & Thomas, Inc.

An STV Engineers Professional Firm
Consulting Engineers
Pottstown, Pennsylvania 19464

PROJECT ABSTRACT

This study is to develop a cost-effective and technically practical modernization program for the steam/power plants at the Indiana Army Ammunition Plant (INAAP).

The recommended modernization approach for the Load, Assemble and Pack (LAP) Area is to construct a new coal-fired central steam plant and distribution system. In the Propellant & Explosives (P&E) Area, modernization of the existing coal-fired facility, Building 401-2, and use of the existing steam distribution system is recommended.

Total expenditures required to complete this modernization program are \$113 million in FY 1983 dollars. Funding allocations are anticipated for FY 1987 through FY 1993.

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EXECUTIVE SUMMARY

PROJECT REQUIREMENTS AND OBJECTIVES

The purpose of this study is to develop a cost-effective and technically practical modernization program for the steam/power plants at the Indiana Army Ammunition Plant (INAAP), Charlestown, Indiana. The objective is to reduce dependence on oil and natural gas.

The program plan presents that method which is consistent with present Army energy goals, is technically feasible, and meets peacetime and mobilization energy requirements.

The plant life-cycle analysis is based on a 25-year life with the period from 1950 to 1975 used as a representative life-cycle for peacetime and mobilization periods. This cycle includes a five-year and seven-year mobilization period.

This study considers both technical and economic criteria in developing the final recommended modernization program.

BACKGROUND

INAAP is located near Charlestown, Indiana, in close proximity to Louisville, Kentucky. The plant is bounded on the west by Indiana Highway 62 and on the east by the Ohio River. The plant's location in relation to Charlestown and Louisville is shown in Figure 1: Location Map.

INAAP consists of approximately 10,500 acres with over 1,700 buildings, 90 miles of roads, and 84 miles of railroad track. General site maps of the P&E Area and LAP Area are shown in the back of this Executive Summary.

The plant is divided as follows:

- . Administration Area
- . Black Powder Area
- . Load, Assemble, and Pack (LAP) Area
- . Propellant and Explosive (P&E) Area
- . Remote, Storage and Miscellaneous Areas

Steam/power facilities are located in various buildings within each area, with steam distribution systems serving the heated buildings along their respective lines.

The LAP and P&E Areas are the only areas considered in the modernization program. Unheated buildings have been omitted since they have no impact on a heat generating facility. Other areas not included in this study are Family Housing, the Black Powder Area, areas of the plant that operate independently, and small heat generating facilities whose load is picked up by larger facilities during mobilization.

Figures 2 and 3 show the area assignments (LAP or P&E) for heated buildings.

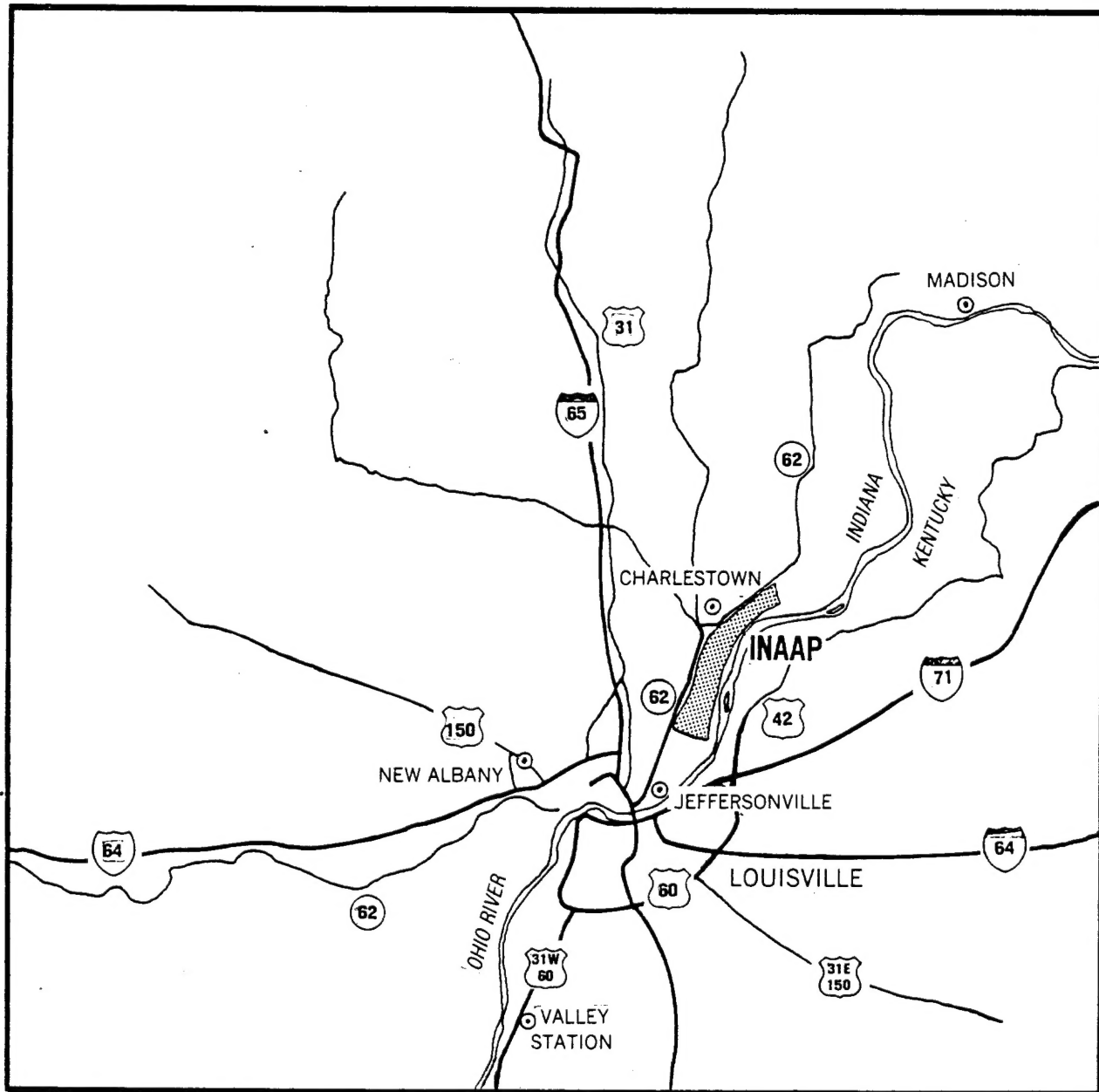


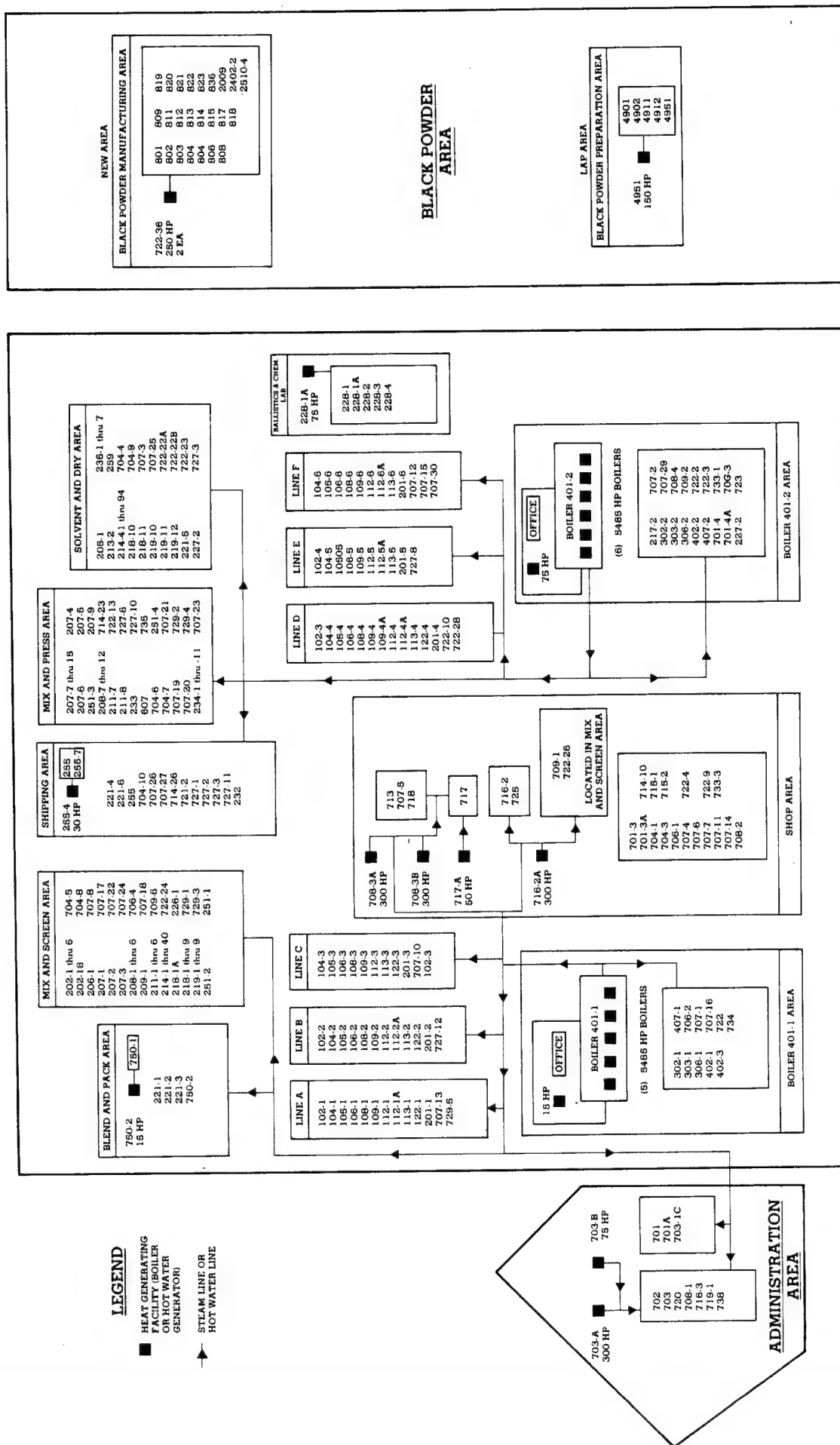
FIGURE 1
Indiana Army Ammunition Plant
Location Map

INDIANA ARMY AMMUNITION PLANT
HEATED BUILDING
AREA ASSIGNMENT CHART
LOAD, ASSEMBLE PACK AREA



FIGURE 3

INDIANA ARMY AMMUNITION PLANT
HEATED BUILDING
AREA ASSIGNMENT CHART
PROPELLANT AND EXPLOSIVES MANUFACTURING AREA



ANALYSIS METHOD

Planning the INAAP modernization program involved analyzing plant energy use in both existing and proposed plant configurations. Existing configuration energy use is based on historical fuel consumption records extrapolated to future requirements. Energy use for the plant in its proposed configuration is projected based on historical records, previous technical reports and studies, and operating modes. Energy consumption profiles are then developed to determine the proposed plant configuration and size. Economic factors related to the proposed plant configuration are then used as an input to the Life-Cycle Cost Analysis.

The study involved assembling the data base to develop a load profile for peacetime and mobilization periods. Existing equipment was analyzed and evaluated to determine the need for physical improvement. Various energy systems were considered with the final selection based on anticipated load centers, effective distribution systems, and site access. Other factors including heat transfer mediums, cogeneration, potential fuels, and combustion techniques were also examined.

A comprehensive life-cycle analysis was performed for the selected methods, which were then ranked in ascending order of capital cost and life-cycle costs.

REGULATORY REQUIREMENTS

All applicable Federal, State, Army and Department of Defense regulations have been complied with in preparing this study and its recommendations.

EMERGING TECHNOLOGIES

The study examined the applicability of using emerging technologies to produce steam for process and heating use. Coal gasification, fluidized bed combustion, and refuse-derived fuels were considered for applicability and fluidized bed combustion is recommended for further study.

ENERGY REQUIREMENTS/MODES OF OPERATION

Energy requirements were established for the two areas under consideration, P&E and LAP for peacetime and mobilization, as detailed in Figures 4, 5, 6, and 7. The study considered the effects of plant activity levels and their relationship to the heat generating facilities, and developed the optimum heating plant arrangement to furnish energy for peacetime and mobilization requirements.

FUEL SELECTION

Coal and biomass were evaluated as candidate fuels. Biomass fuels were investigated as to their local availability and long term supply. Of the biomass fuels investigated (agricultural crops, agricultural crop residue, farm animal residue, wood and wood residue, special energy crops in the form of fast-growth hybrid poplars, and urban waste), fast-growth hybrid poplars were found to be most promising. Hybrid poplars could possibly be used to

MILLION POUNDS
OF STEAM

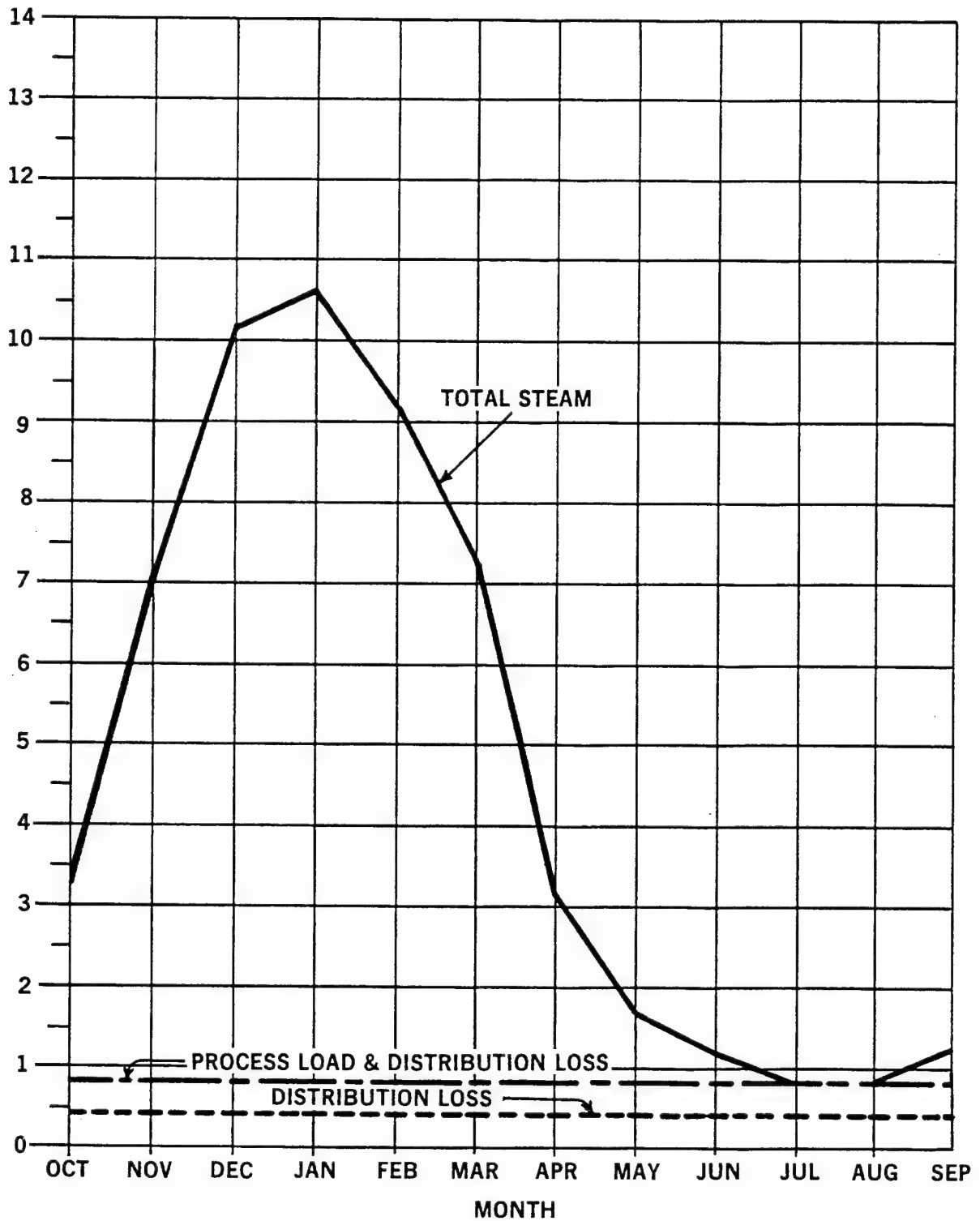


FIGURE 4
BASE YEAR PEACETIME MINIMUM
LAP AREA

MILLION POUNDS
OF STEAM

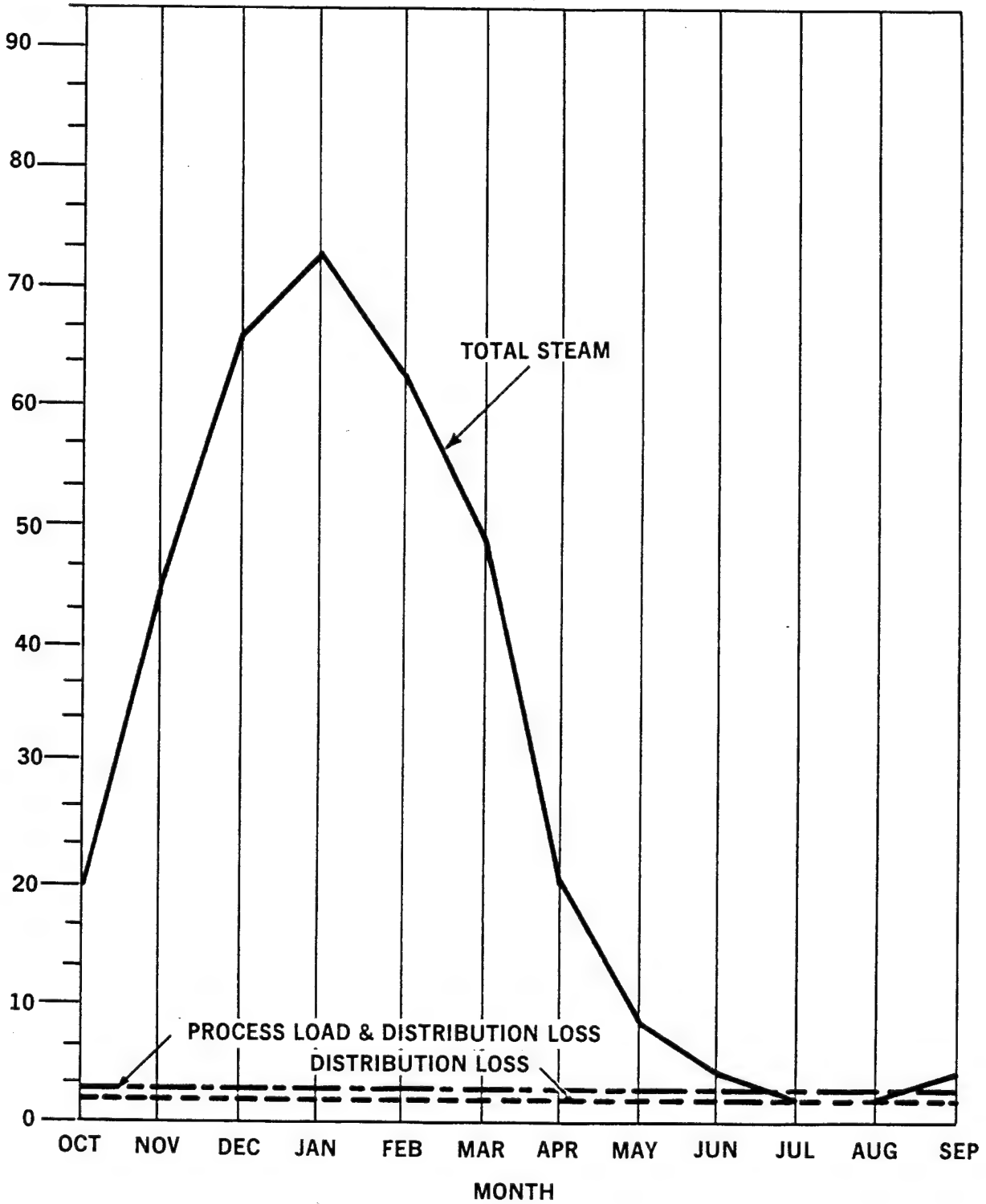
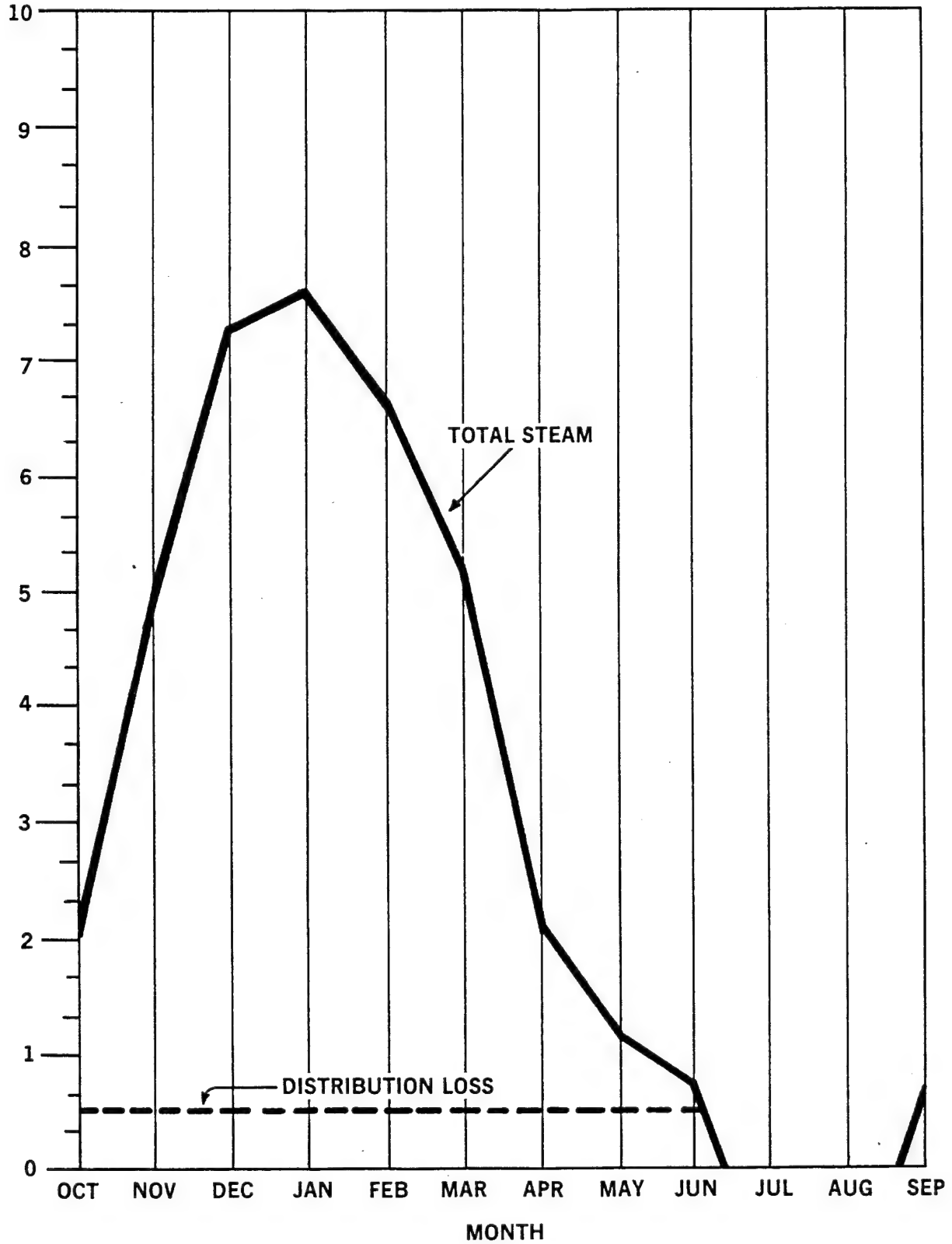


FIGURE 5
BASE YEAR MOBILIZATION MAXIMUM
LAP AREA

**MILLION POUNDS
OF STEAM**



**FIGURE 6
BASE YEAR PEACETIME MINIMUM
P&E AREA**

MILLION POUNDS
OF STEAM

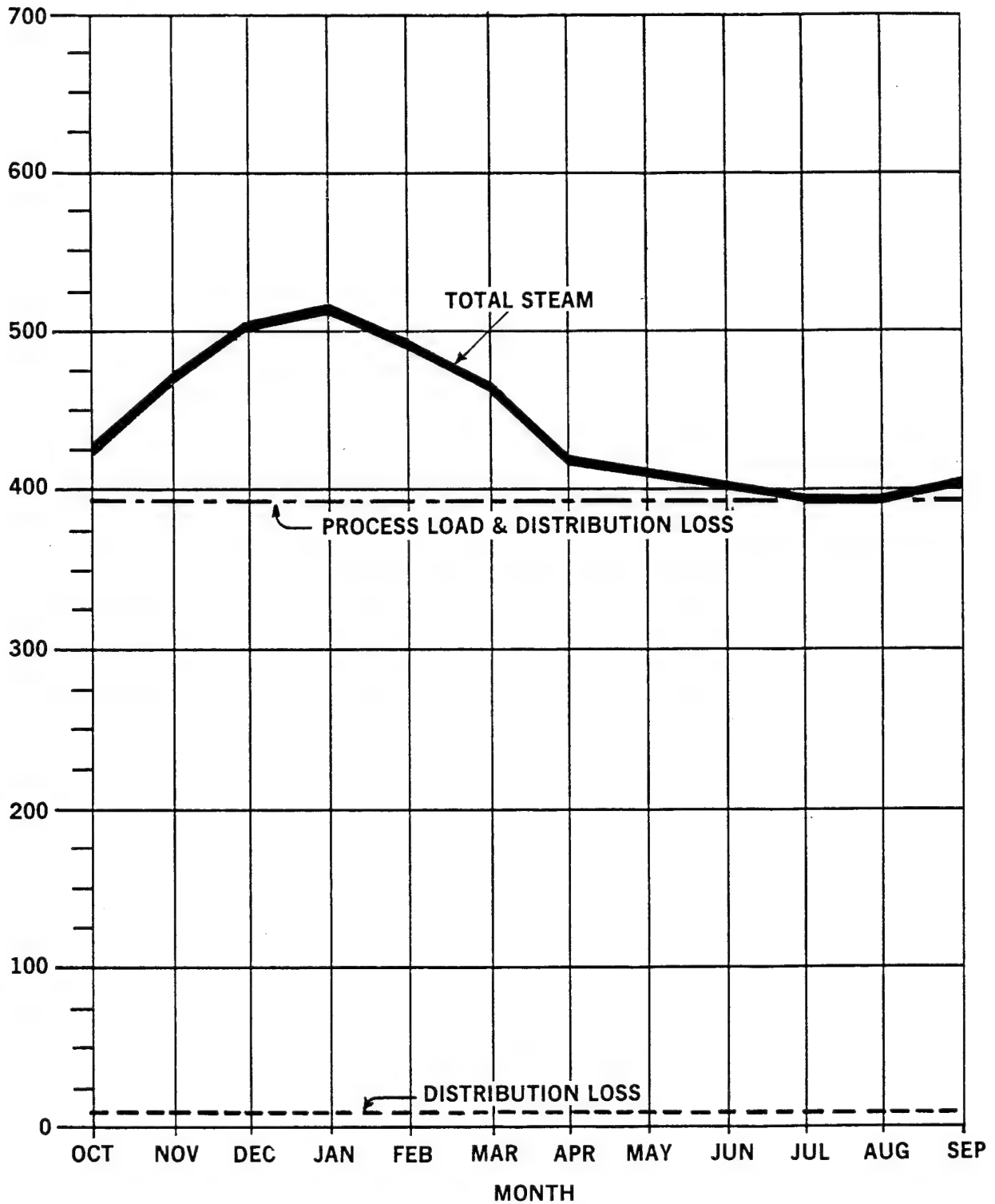


FIGURE 7
BASE YEAR MOBILIZATION MAXIMUM
P&E AREA

replace coal or used in conjunction with coal. Eastern Kentucky coal, however, was chosen as the primary fuel. Eastern Kentucky coal has the following approximate values:

As received BTU value	11,825
Ash content	7.4%
Moisture content	9.8%
Sulfur content	2.8%
Ash fusion temperature	2,015°F

LAP AREA CENTRAL PLANT ALTERNATIVES

Eight possible heat generation methods were considered for the LAP Area: Construct New Coal-Fired Central Steam Plant, Construct New Coal-Fired Central HTW Plant, Convert Steam/Power Plant 2541 to Fire Coal, Install New Coal-Fired Steam Generating Equipment in 2541, Install New Coal-Fired HTW Generating Equipment in 2541, Modernize Existing Equipment and Continue Firing No. 2 Oil, Construct Small Coal-Fired Plants at Each Specific Area, and Expand the Capacity of Steam/Power Plant 2541 if Converted to Fire Coal.

The above were screened and three identified as worthy of detailed technical and economic analysis.

- . New Coal-Fired Steam Plant
- . New Coal-Fired HTW Plant
- . Modernize Existing Equipment and Continue Firing No. 2 Oil

The New Coal-Fired Steam Plant was selected as the preferred method because of its lower initial and life-cycle costs. This plant would satisfy a peak steam mobilization level requirement of 117,000 Lbs./Hr.

The plant will be centrally located in the LAP Area near existing roads and rail spurs with room for the heating plant house, fuel storage and handling facilities, ash handling facilities, and pollution abatement facilities. The heating plant will contain five, 30,000 Lbs./Hr. steam boilers and associated appurtenances. Heat distribution will be accomplished by an aboveground piping distribution system.

P&E AREA CENTRAL PLANT ALTERNATIVES

Four possible heat generation methods were considered for the P&E Area: Construct New Coal-Fired Central Steam Plant, Construct New Coal-Fired Central HTW Plant, Modernize Existing Equipment Firing No. 2 Oil, and Modernize Existing Equipment Firing Coal.

Of the four methods, two were selected for technical and economic analysis:

- . Construct New Coal-Fired Central Steam Plant
- . Modernize Existing Equipment Firing Coal

Modernizing Existing Equipment Firing Coal was selected as the most cost-effective on the basis of the lowest initial cost and the lowest life-cycle cost. The recommended plan would satisfy a peak mobilization steam requirement of 725,000 Lbs./Hr.

The existing steam plant in Building 401-2, with its six 170,000 Lbs./Hr. steam boilers, will be modernized to meet the facilities steam requirements. The existing equipment will be refurbished or replaced as required. New pollution abatement facilities will be provided to meet regulations. The existing steam distribution system will be reused.

PROGRAM PLAN IMPLEMENTATION

A three-phase plan, shown in Figure 8: Overall Program Plan, is recommended to implement the Steam/Power Modernization Program for INAAP. The three-phase plan is:

- Phase I: Interconnect steam/power plant steam distribution systems presently served by steam/power plants 401-1 and 401-2.
- Phase II: Modernize steam/power plant 401-2 in the P&E Area.
- Phase III: Construct a new coal-fired steam generating plant for the LAP Area.

The proposed funding profile is shown in Figure 9: Funding Profile. Total expenditures for all phases is approximately \$113 million in 1983 dollars.

**FIGURE 8
INDIANA ARMY AMMUNITION PLANT
OVERALL PROGRAM PLAN**

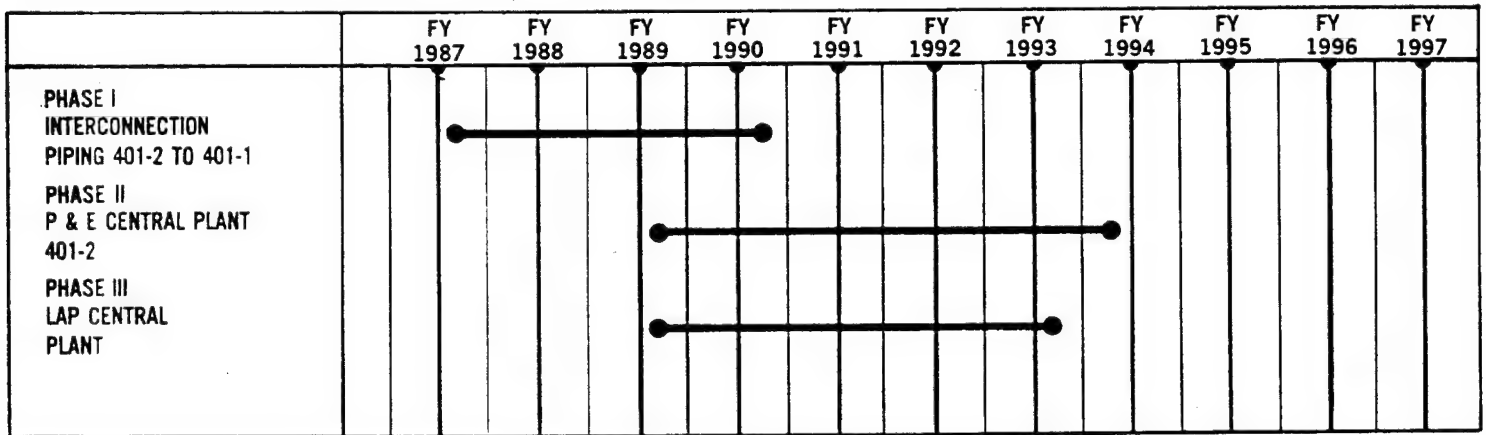
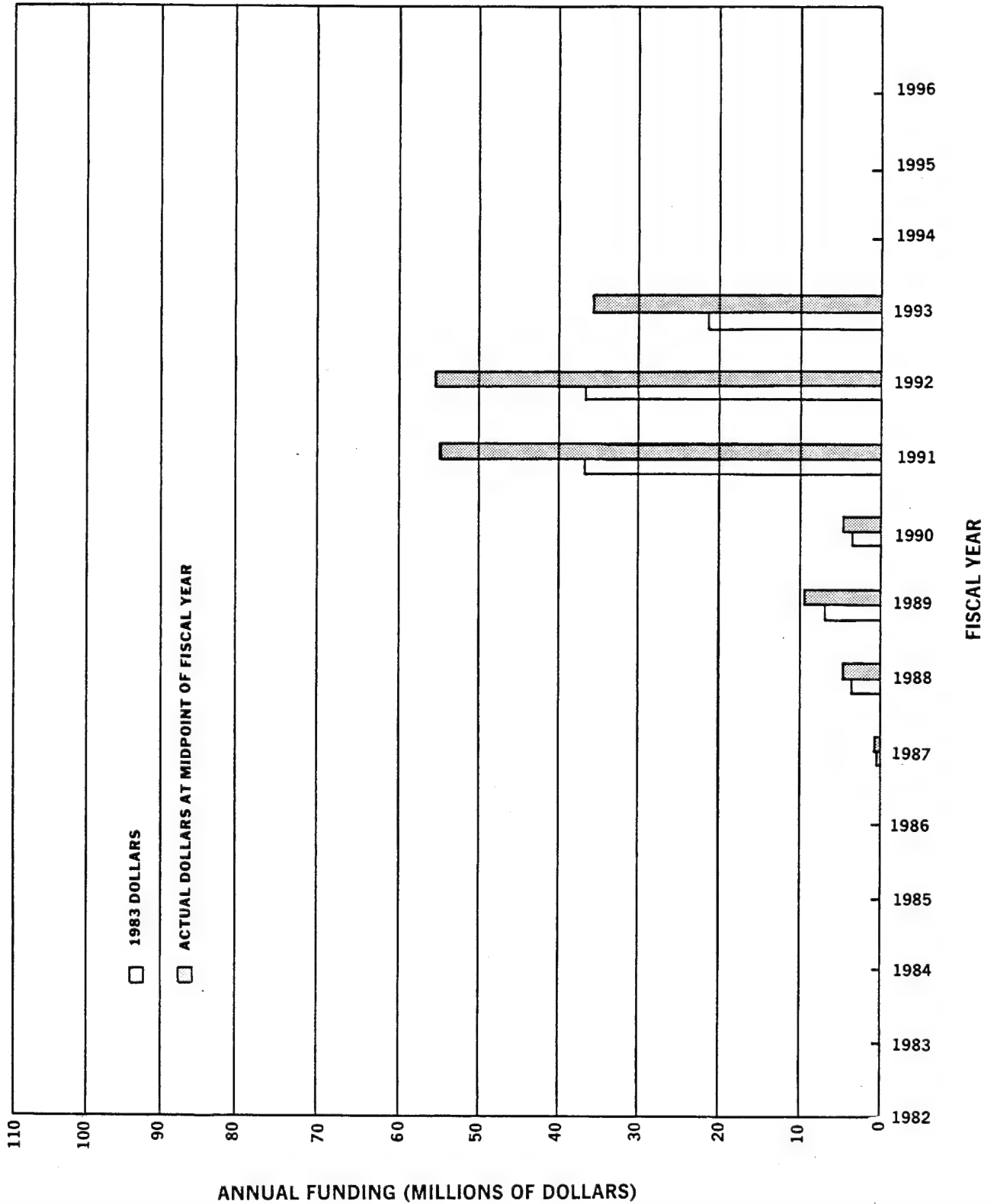
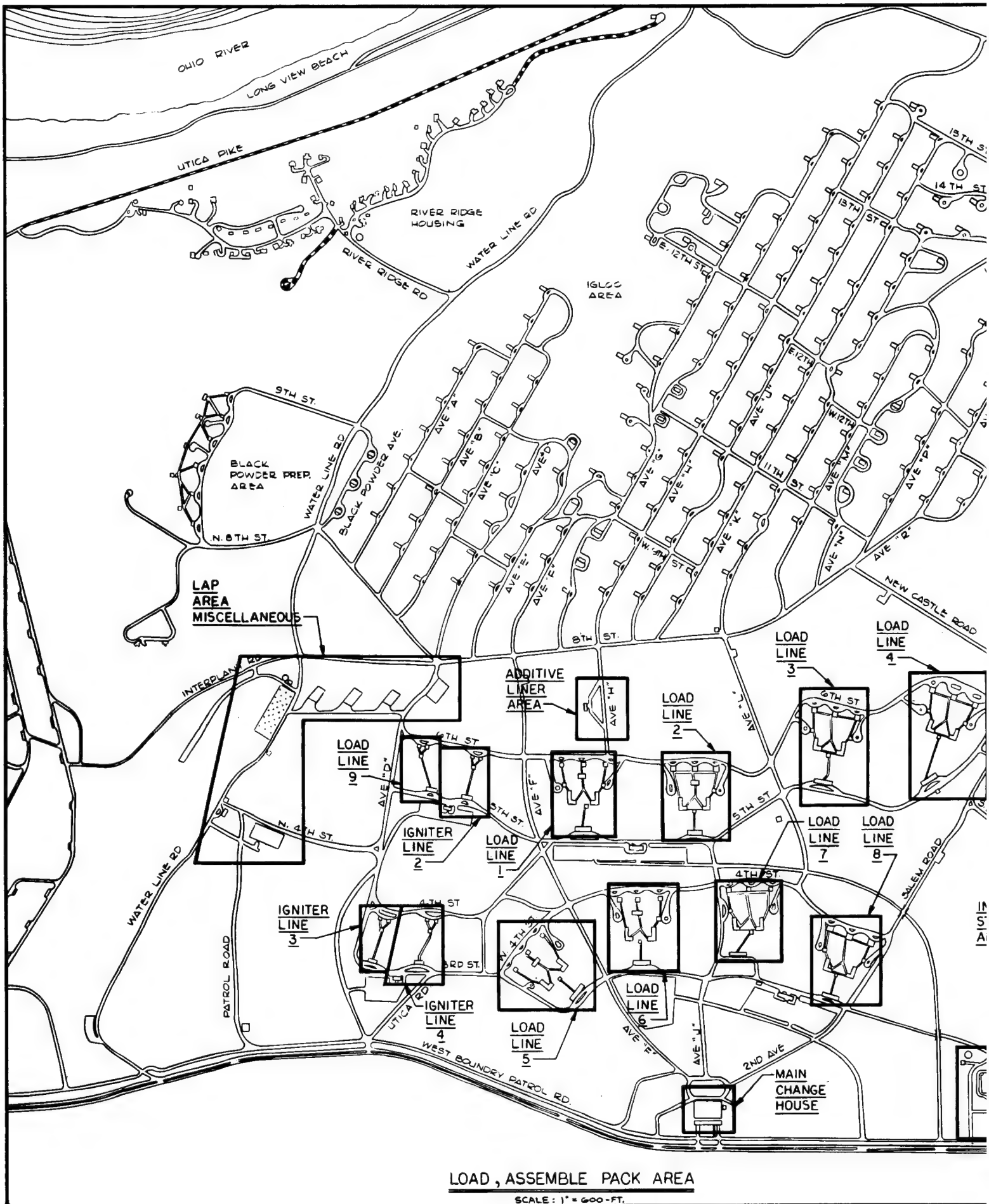
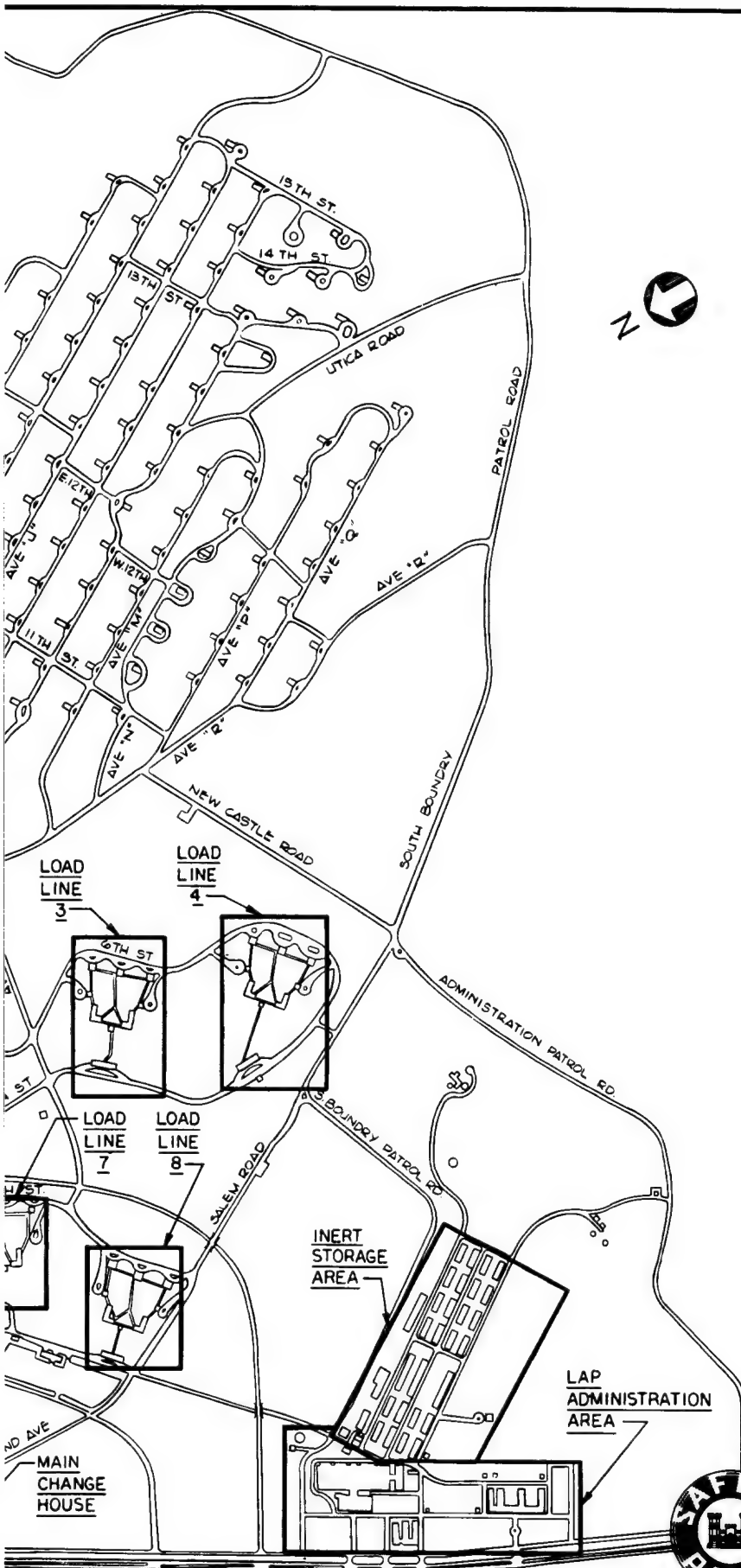


FIGURE 9
FUNDING PROFILE
INDIANA ARMY AMMUNITION PLANT





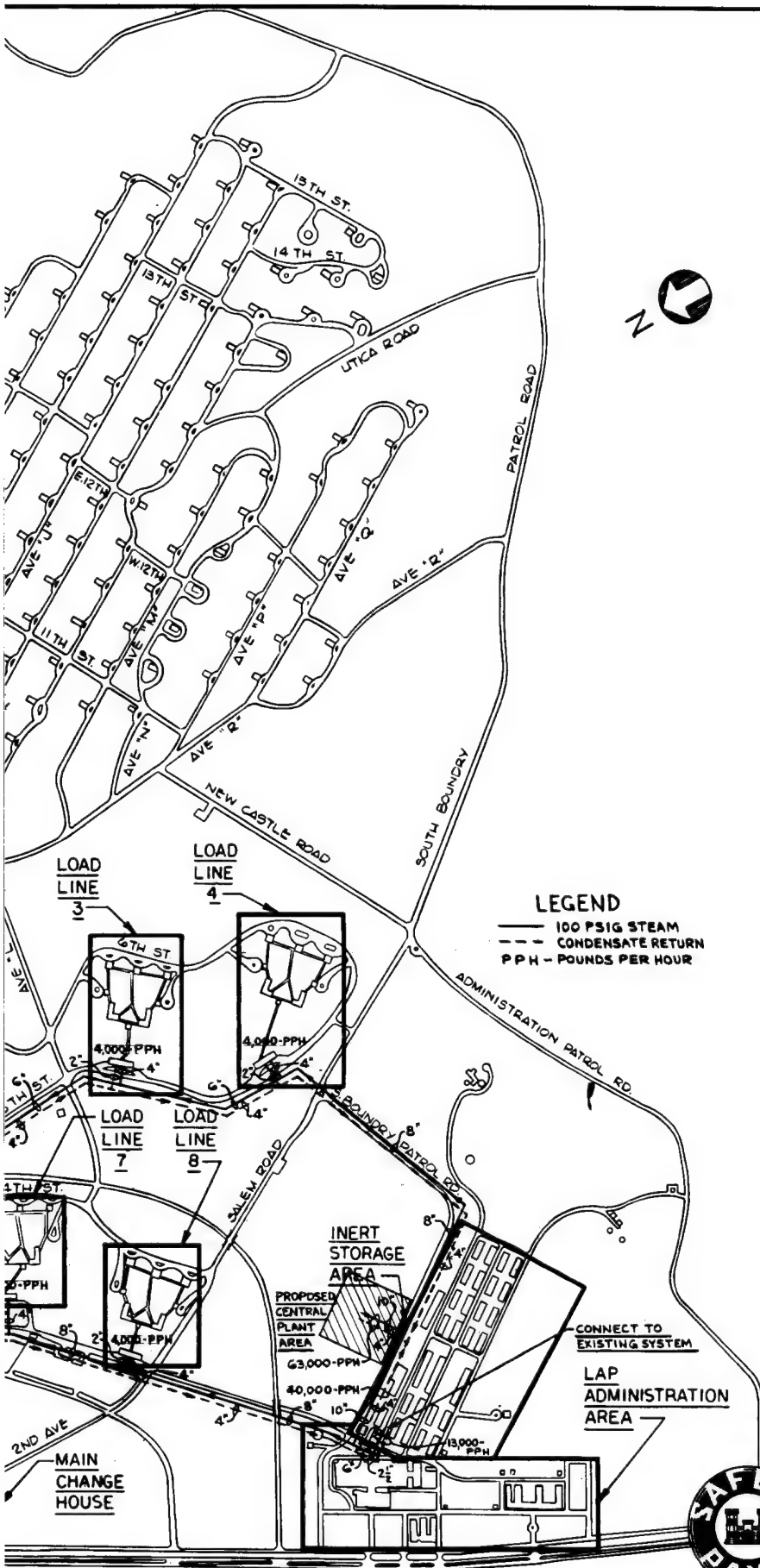


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DESIGNED BY: KNOTSON	STEAM/POWER PLANT MODERNIZATION		
DRAWN BY: FREDERICK	INDIANA ARMY AMMUNITION PLANT		
CHECKED BY: CREMI	LAP AREA SITE PLAN		
SUBMITTED BY:			
ARCHITECT/ENGINEER			
RECOMMENDER:			
CHIEF, DESIGN BRANCH	CHIEF, ENGINEERING DIVISION	DATE: JULY 2, 1982	
APPROVER:	SCALE: AS SHOWN	SPEC. NO. DACA45	
DRAWING NUMBER		FIGURE II -05-01	
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MODIFICATION NO.

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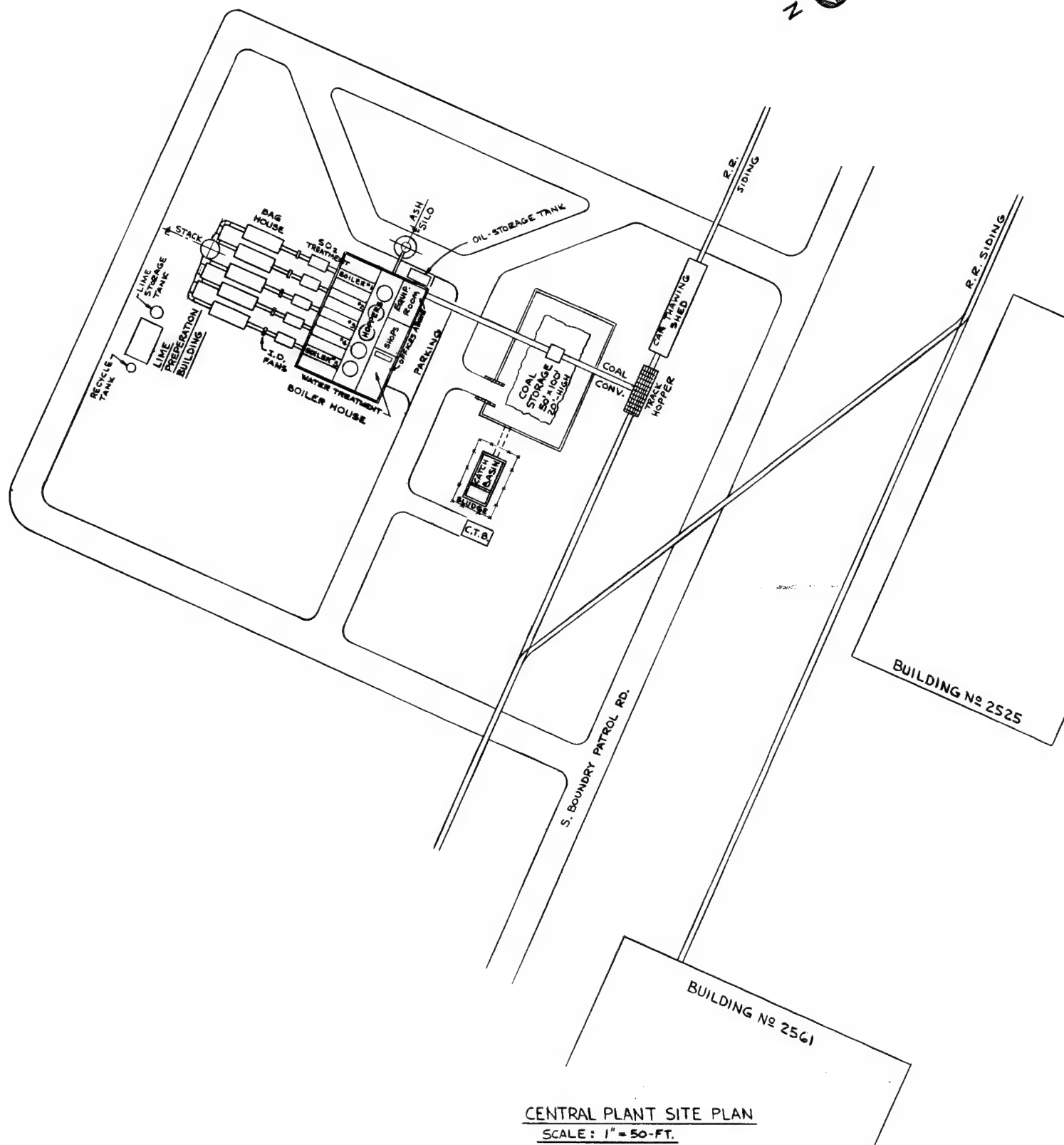
— 100 PSIG STEAM
 --- CONDENSATE RETURN
 PPH - POUNDS PER HOUR

GRAPHIC SCALE

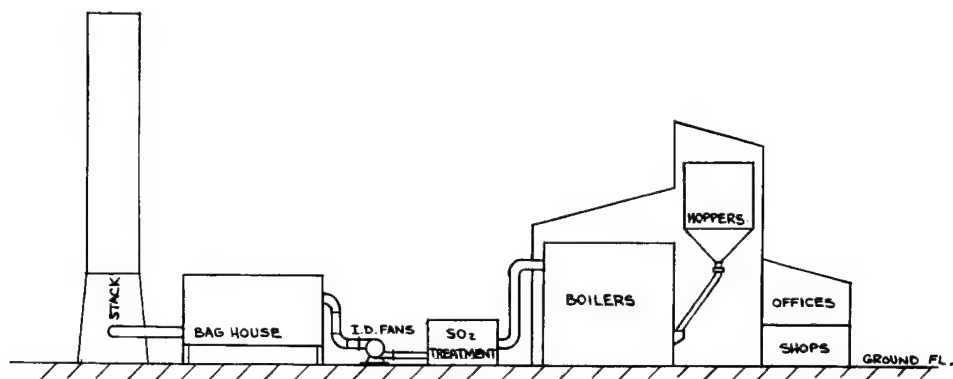
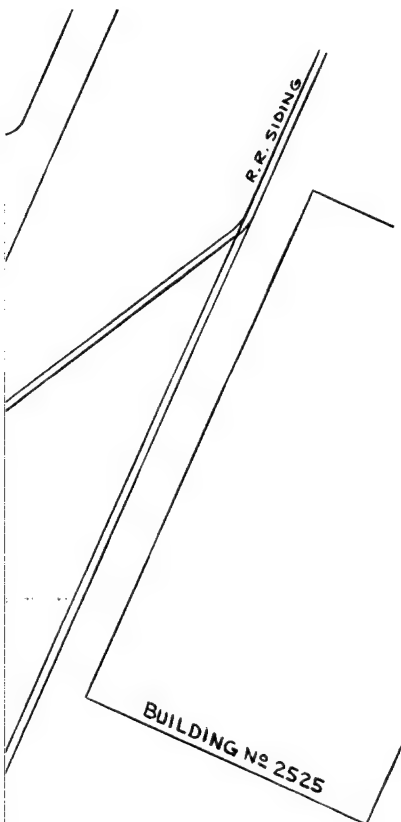
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SUBMITTED BY		STEAM/CONDENSATE DISTRIBUTION SYSTEM	
ARCHITECT-ENGINEER		APPROVED	DATE
CHIEF, DESIGN BRANCH		CHIEF, ENGINEERING DIVISION	JULY 2, 1982
APPROVED		SCALE AS SHOWN	SHEET NO. DCA43
THIS PLAN ACCOMPANIES CONTRACT NO. DCA43			FIGURE II-05-03
MODIFICATION NO.			

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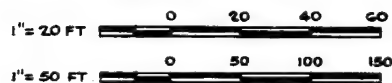


CENTRAL PLANT SITE PLAN
SCALE: 1" = 50-FT.



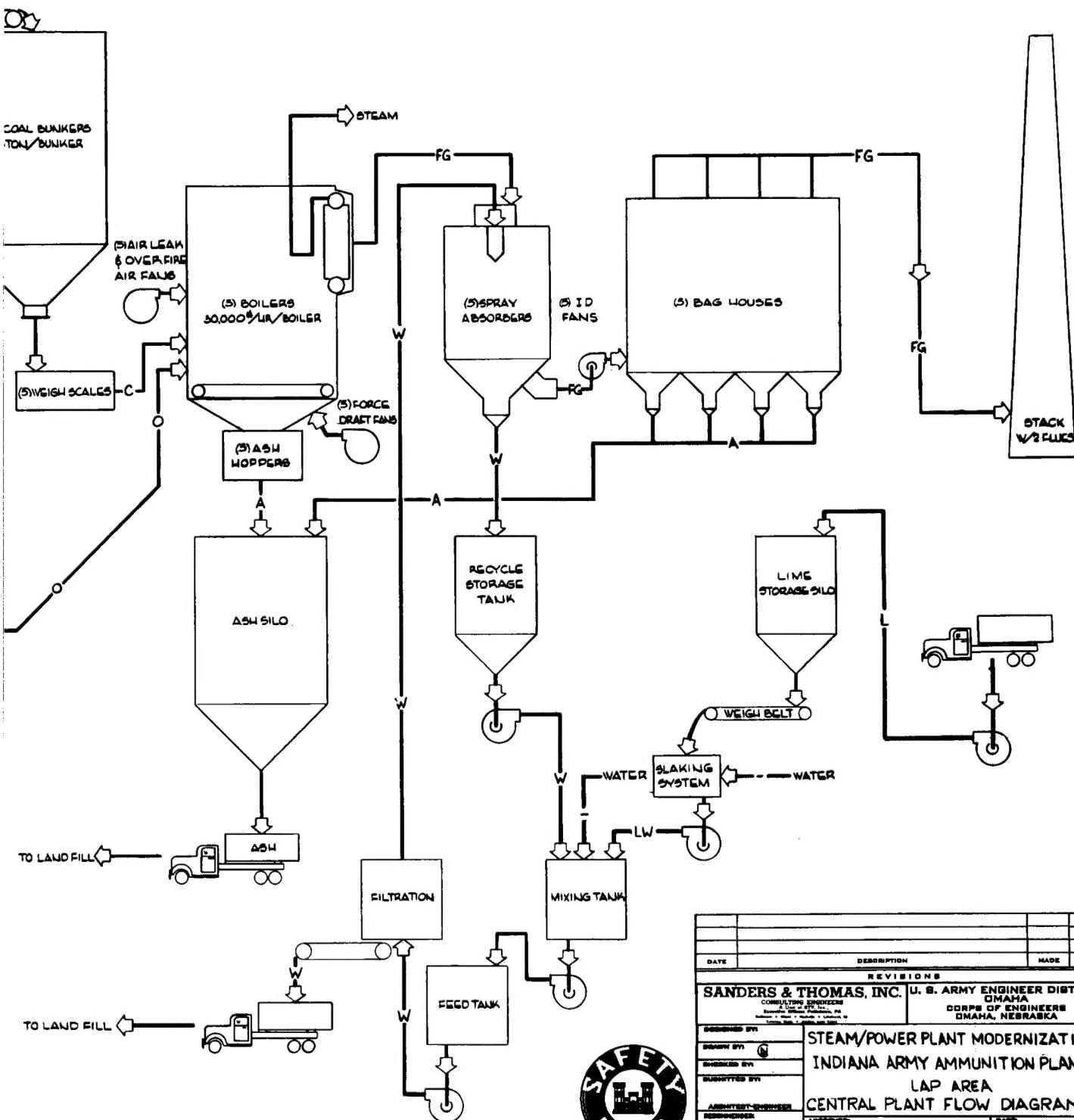
SECTION THRU BOILER HOUSE
SCALE: 1" = 20'-FT.

GRAPHIC SCALES



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APPROVED		SCALE: AS SHOWN		DRAWING NUMBER	
THIS PLAN ACCOMPANIES CONTRACT NO. DACA45		MODIFICATION NO.		FIGURE II-05-04	
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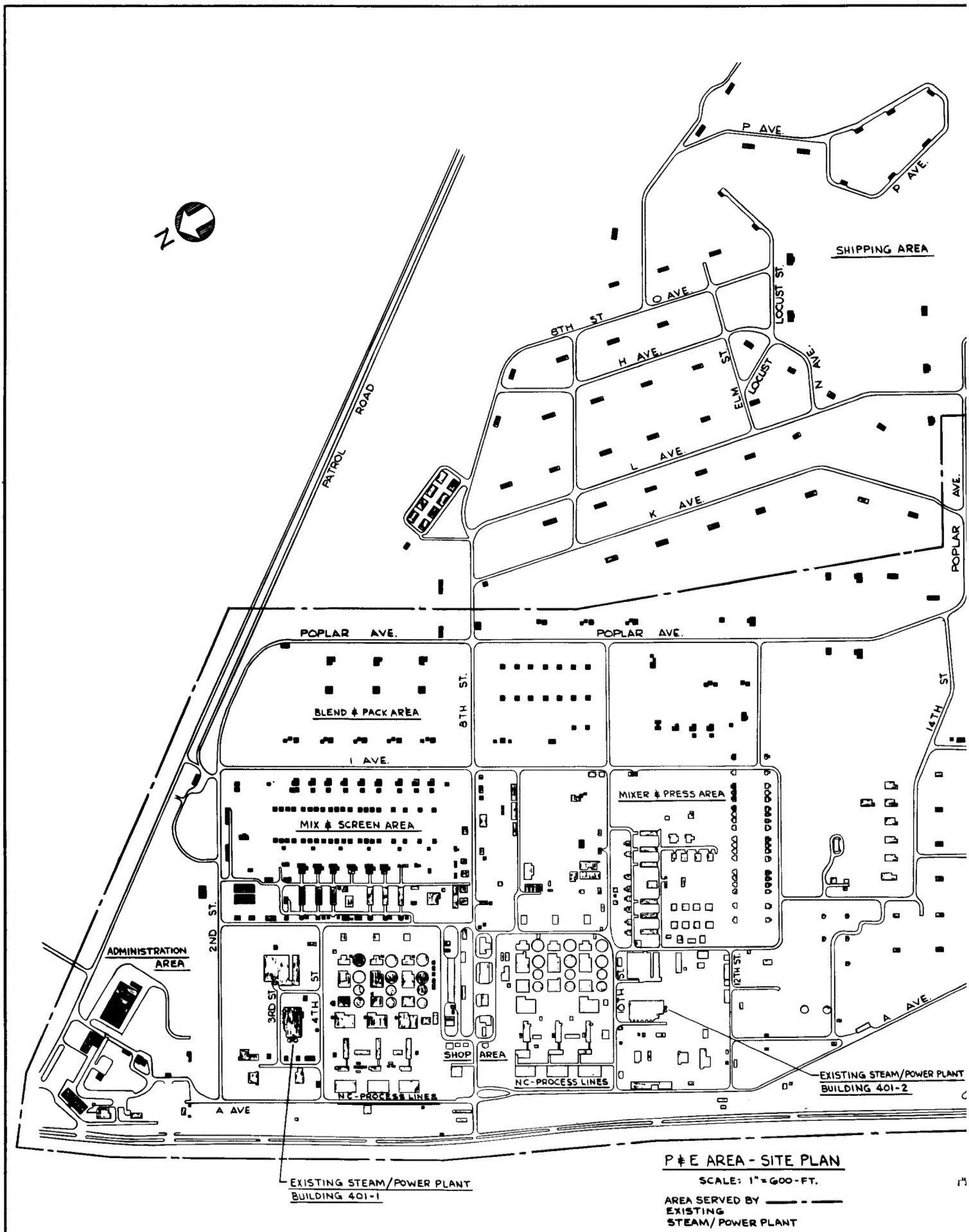




DATE	DESCRIPTION	MADE	APPROVED
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DESIGNED BY	STEAM/POWER PLANT MODERNIZATION		
DRAWN BY	INDIANA ARMY AMMUNITION PLANT		
CHECKED BY	LAP AREA		
APPROVED BY	CENTRAL PLANT FLOW DIAGRAM		
APPROVED	DATE	JULY 2 1982	
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APPROVED	SHUT	FIGURE II-05-05	



THIS PLAN ACCOMPANIES CONTRACT NO.
DACA45
MODIFICATION NO.



P#E AREA - SITE PLAN

SCALE: 1" = 600'-FT.

AREA SERVED BY
EXISTING
STEAM/ POWER PLANT

EXISTING STEAM/POWER PLANT
BUILDING 401-1

EXISTING STEAM/POWER PLANT
BUILDING 401-2

SHIPPING AREA

POPLAR AVE.

POPLAR AVE.

BLEND & PACK AREA

I AVE.

MIX & SCREEN AREA

MIXER & PRESS AREA

ADMINISTRATION
AREA

2ND ST.

3RD ST.

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504TH ST.

506TH ST.

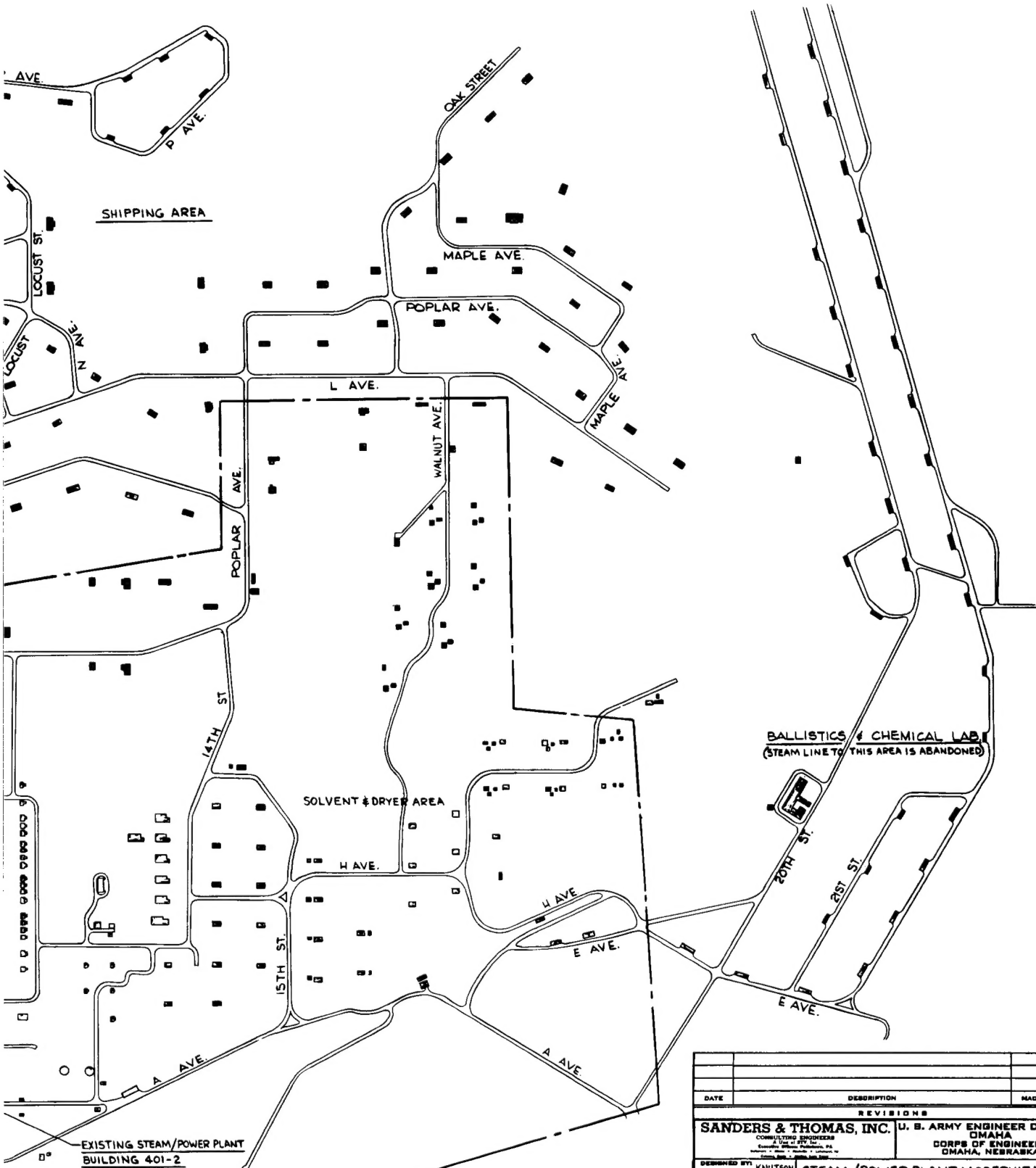
508TH ST.

510TH ST.

512ND ST.

514TH ST.

516TH ST



- SITE PLAN

1" = 600-FT.

Y - - - - -

R PLANT

GRAPHIC SCALE

1" = 600 FT 0 600 1200 1800



THIS PLAN ACCOMPANIES CONTRACT NO. DACA45 MODIFICATION NO.

DATE		DESCRIPTION		MADE	APPRO
REVISIONS					
SANDERS & THOMAS, INC. CONSULTING ENGINEERS				U. S. ARMY ENGINEER DISTRICT OMAHA, NEBRASKA	
DESIGNED BY: KNUITSON				STEAM/POWER PLANT MODERNIZATION	
DRAWN BY: FREDERICK				INDIANA ARMY AMMUNITION PLANT	
CHECKED BY: CREMI				P & E AREA - SITE PLAN	
SUBMITTED BY:					
ARCHITECT-ENGINEER					
RECOMMENDER:					
CHIEF, DESIGN BRANCH				CHIEF, ENGINEERING DIVISION	
APPROVER:				DATE: JULY 2, 1982	
				SCALE: AS SHOWN	
				SHEET NO. DACA45	
				DRAWING NUMBER	
				FIGURE II-05-06	
COL. D. E. DISTRICT ENGINEER				SHEET	

(2)